

# Work Order ID 50053

July 7, 2009 9:16:08 AM



Page 1

Item ID: D2010-103

BK

Accept



Setup Start



Revision ID: D

Stop



Item Name: Mirror Arm, 500

Start Date: 7/07/09 Start Qty: 15.00



Cust Item ID:

Required Date: 7/14/09 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2010	Rev D

100 0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727  
Identify as D2010-103

M-h 09/07/10 (15x)

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend as per Dwg D2010 using bending Jig D2010-103T2  
2- Deburr ends

M-h 09/07/10 (15x)

120 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-flare before installing plug as per dwg D2010  
2-Install D2057 plug as per Dwg D2010

M-h 09/07/10 (15x)

# Work Order ID 50053

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Item ID:	D2010-103	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Mirror Arm, 500					
Start Date:	7/07/09	Start Qty:	15.00		Cust Item ID:	
Required Date:	7/14/09	Req'd Qty:	15.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	=> Sorloz/10 (15)						
140  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: 12:30pm FINISH TIME: 1:00pm	0.00  0.00	OVEN TEMPERATURE: 320°F M109091 09-07-13 (15) JEF						
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	09-07-13 (15) BR						

# Work Order ID 50053



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July 7, 2009 9:16:08 AM

Item ID: D2010-103

Accept



Setup Start



Revision ID: D

Stop



Item Name: Mirror Arm, 500

Start Date: 7/07/09 Start Qty: 15.00



Cust Item ID:

Required Date: 7/14/09 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>201</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/14/13

SP

09/07/14

u 09.07.14

# Picklist Print

Page 1

July 7, 2009 9:16:07 AM

Work Order ID: 50053

Parent Item: D2010-103RevD

Parent Item Name: Mirror Arm, 500


Comments:

Start Date: 7/07/09

Required Date: 7/14/09


Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	149.2700	23.6842			
												
304 RD Tube .500 x .049W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	149.27	
111814	149.27	

M111814 m-h 09/07/09

D2057RevC		Manufactured	No			110	Each	82.0000	15.0000			
												
Plug												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	82	
34366	42	
40048	40	

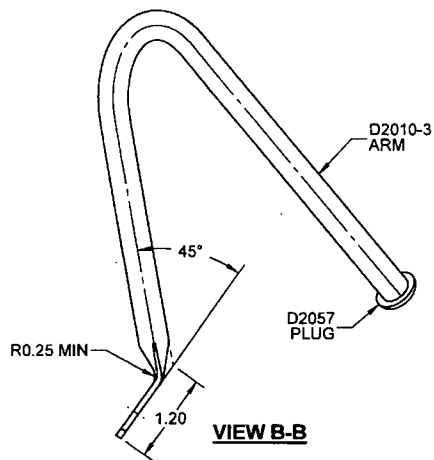
3 400 48

ISX

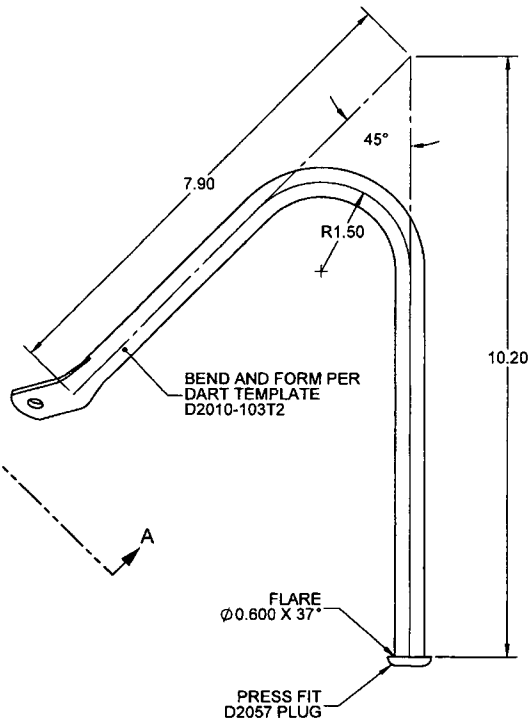
m-h 09/07/09

8 7 6 5 4 3 2 1

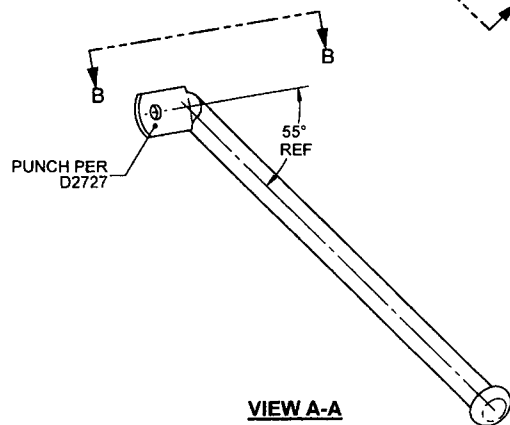
QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



**VIEW B-B**



**D2010-103 ARM**



**VIEW A-A**

**REFERENCE ONLY**

50053

**RELEASED**  
02 06 11

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2010	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 4
APPROVED		MIRROR BRACKET	
DE APPR.		SCALE	
DATE	08.06.10	NTS	

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8 7 6 5 4 3 2 1

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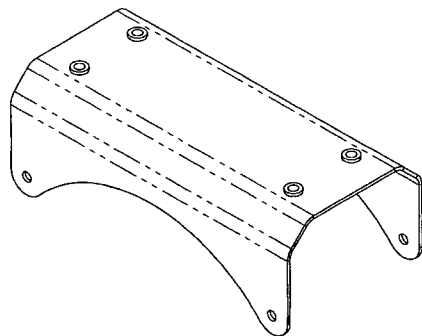
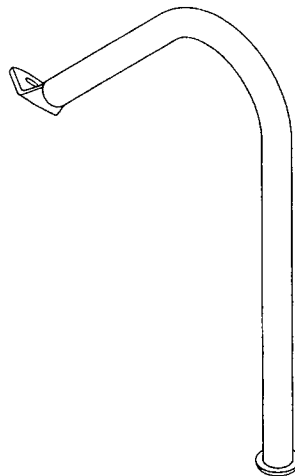
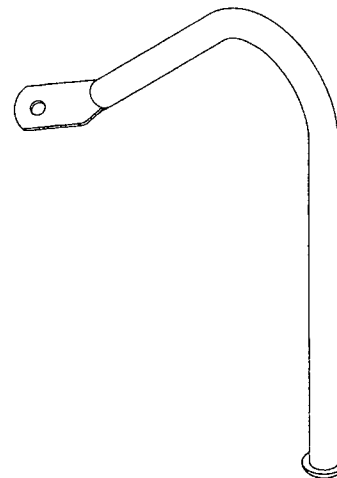
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**D2010-101 MIRROR BRACKET****D2010-103 ARM****D2010-104 ARM**

50053

RELEASED  
08.06.10

REFERENCE ONLY

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D2010	SHEET 1 OF 4
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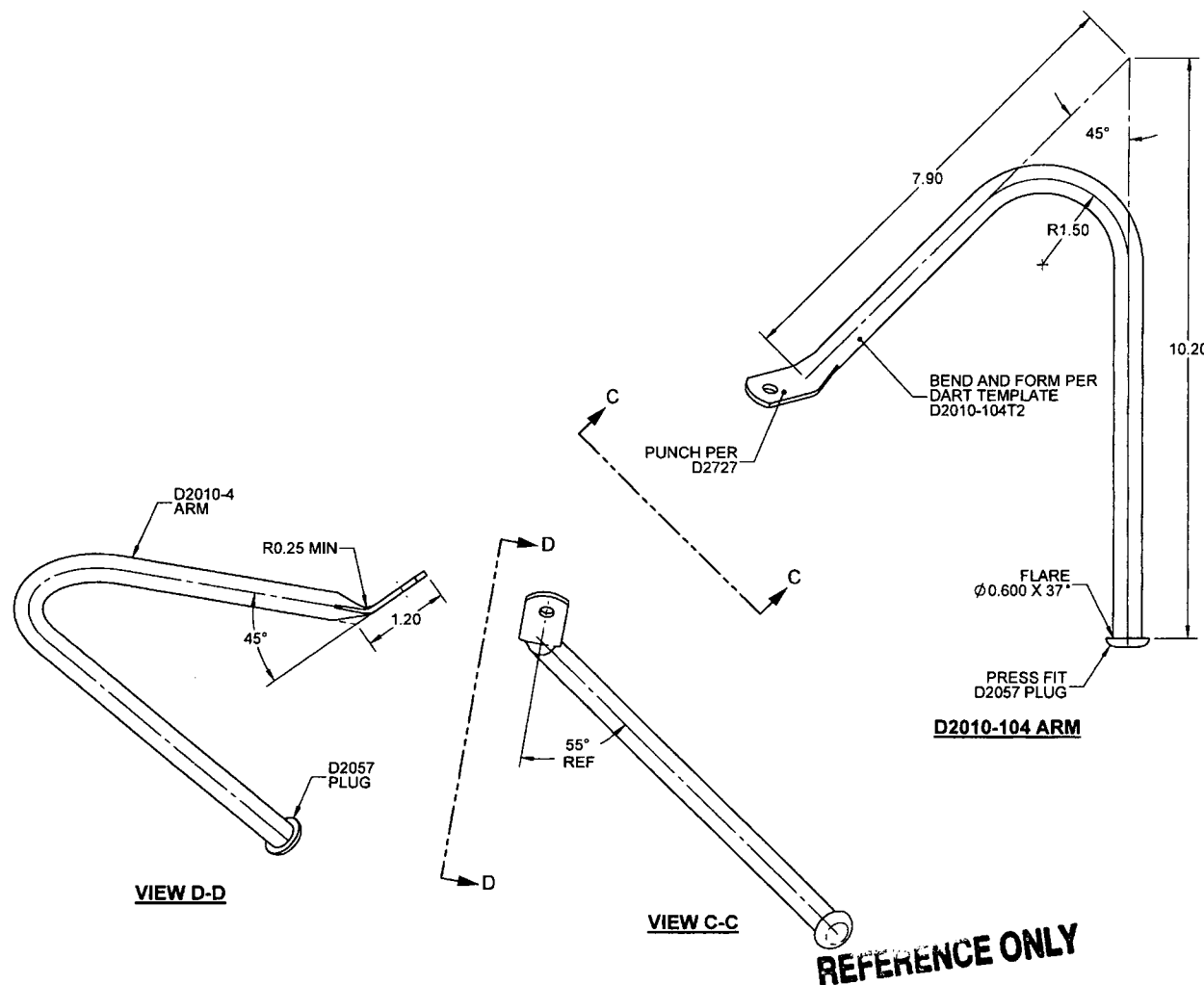
4

3

2

1

QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



RELEASED

- NOTES:
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\varnothing 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

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